



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4131-1
Job Sheet 185984



Part No: D4131-1

Job Qty: 10 ea

Part Name: Front Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 5 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		11/29/18	0.00	0.96	Waterjet - Flow		SE 11/29/18
120	QC	10 pcs		11/29/18	0.00	0.00	QC8		38
130	Packaging	10 pcs		11/29/18	0.00	0.00	Packaging3		1/32 9-89
140	QC21-SA	10 Ea		11/29/18	0.00	0.00	QC21		21 NOV 14 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	1.8070 sf (.1807 ea)	100-Waterjet - Flow - 1	512 3199

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	2	332	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Front Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	0.193	Diameter
2	Front Plate	0.405Inches ± 0.010	0.415 0.395	0.407	
3	Front Plate	4.600Inches ± 0.010	4.610 4.590	4.604	
4	Front Plate	3.480Inches ± 0.010	3.490 3.470	3.478	
5	Front Plate	4.810Inches ± 0.030	4.840 4.780	4.808	
6	Front Plate	0.670Inches ± 0.030	0.700 0.640	0.673	
7	Front Plate	5.410Inches ± 0.030	5.440 5.380	5.412	
8	Front Plate	3.914Inches ± 0.010	3.924 3.904	3.915	
9	Front Plate	0.750Inches ± 0.030	0.780 0.720	0.754	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR I _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐									
Cross tube ☐	Water Jet ☐	Engineering ☐																				
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Composite ☐	Supplier ☐																					
		MRB (QSI042) Approval																				
		Completed By																				
		Lead hand / Supervisor Approval Verification																				
		QC / QA Coordinator Approval																				
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S126643 Part: D4131 - 1 Job No: 185984 Serial No/Batch: S126643 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/10/18																						
Environment _____ Design _____ Doc/Data _____ Equip/Tooling _____ Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____	Offset/Setup _____ Supplier _____ Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____	CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
☐ Power Loss/Surge	☐ Positioned Wrong																					
☐ Folio/Program	☐ Outside Dimensions																					
☐ Grain	☐ Over/Under tolerance																					
☐ Weld	☐ Part Incorrect																					
☐ Wrong Stock Pulled	☐ Part Lost/Missing																					
☐ Out of Sequence	☐ Part Moved																					
☐ Off-set	☐ Drawing																					
☐ Mislabeled	☐ Finish																					
☐ Fit/Function	☐ Misread																					
☐ Misaligned/off center	☐ Turning Sequence																					
OTHER : _____																						

0,0 46

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							